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D2581

Job Sheet 199753



568  
[Signature]

Part No: D2581

Job Qty: 40 pcs

Part Name: Mounting Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/30/19

Job Tracking No:

Due Date: 9/27/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A1 IPP D 01.07.17 Added info to step 2 SM

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation           | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|---------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                     |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 100   | Waterjet - Flow - 1 | 40 pcs | 9/27/19    | 9/27/19  | 0.17      | 1.95    | Waterjet - Flow       |           | 02/19/09/04 |
| 120   | QC 8                | 40 pcs | 9/27/19    | 9/27/19  | 0.00      | 0.00    | QC 8 - 12             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 14             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 17             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 20             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 25             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 3              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 32             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 33             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 35             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 39             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 4              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 44             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 45             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 49             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 58             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 8              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 9              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 68             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 67             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 1 (A)          |           |             |
|       |                     |        |            |          |           |         | QC 8 - 47             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 40             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 52             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 23             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 57             |           |             |
| 130   | Small Fab - 2 - B4B | 40 pcs | 9/27/19    | 9/27/19  | 0.00      | 0.33    | Small Fab - 1 - B4B   |           |             |
|       |                     |        |            |          |           |         | Small Fab - 2 - B4B   |           |             |
|       |                     |        |            |          |           |         | Small Fab - 3 - B4B   |           |             |
|       |                     |        |            |          |           |         | Small Fab - 4 - B4B   |           |             |
|       |                     |        |            |          |           |         | Small Fab - 5 - B4B   |           |             |

counted 56

D'S  
40  
SEP 11 2019 9:59

SEP 10 2019

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|                                        |        |         |           |                        |                   |
|----------------------------------------|--------|---------|-----------|------------------------|-------------------|
| 140 QC 5                               | 40 pcs | 9/27/19 | 0.00 0.00 | Small Fab - 6 - B4B    |                   |
|                                        |        |         |           | Small Fab - 7 - B4B    |                   |
|                                        |        |         |           | Small Fab - 8 - B4B    |                   |
|                                        |        |         |           | QC 5 - 10              |                   |
|                                        |        |         |           | QC 5 - 12              |                   |
|                                        |        |         |           | QC 5 - 17              |                   |
|                                        |        |         |           | QC 5 - 18              |                   |
|                                        |        |         |           | QC 5 - 19              |                   |
|                                        |        |         |           | QC 5 - 22              |                   |
|                                        |        |         |           | QC 5 - 24              |                   |
|                                        |        |         |           | QC 5 - 3               |                   |
|                                        |        |         |           | QC 5 - 43              |                   |
|                                        |        |         |           | QC 5 - 49              |                   |
|                                        |        |         |           | QC 5 - 51              |                   |
|                                        |        |         |           | QC 5 - 58              |                   |
|                                        |        |         |           | QC 5 - 68              |                   |
|                                        |        |         |           | QC 5 - 9               |                   |
|                                        |        |         |           | QC 5 - 50              |                   |
|                                        |        |         |           | QC 5 - 30              |                   |
|                                        |        |         |           | QC 5 - 40              |                   |
|                                        |        |         |           | QC 5 - 61              | DAS<br>61<br>9-89 |
|                                        |        |         |           | QC 5 - 81              |                   |
| 150 Packaging 3-1 - Stock - B4B 40 pcs | 40 pcs | 9/27/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |                   |
|                                        |        |         |           | Packaging 3 - 2 - B4B  |                   |
|                                        |        |         |           | Packaging 3 - 3 - B4B  |                   |
|                                        |        |         |           | Packaging 3 - 4 - B4B  |                   |
|                                        |        |         |           | Packaging 3 - 5 - B4B  |                   |
|                                        |        |         |           | Packaging 3 - 6 - B4B  | DAS<br>28<br>9-89 |
|                                        |        |         |           | Packaging 3 - 7 - B4B  |                   |
|                                        |        |         |           | Packaging 3 - 8 - B4B  |                   |
|                                        |        |         |           | Packaging 3 - 9 - B4B  |                   |
|                                        |        |         |           | Packaging 3 - 10 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 11 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 12 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 13 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 14 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 15 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 16 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 17 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 18 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 19 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 20 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 21 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 22 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 23 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 24 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 25 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 26 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 27 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 28 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 29 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 30 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 31 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 32 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 33 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 34 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 35 - B4B |                   |
|                                        |        |         |           | Packaging 3 - 36 - B4B | DAS<br>21<br>9-89 |
| 160 QC 21 - SA                         | 40 pcs | 9/27/19 | 0.00 0.00 | QC 21 - SA - 21        | DAS<br>21<br>9-89 |

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QC 21 - SA - 70

QC 21 - SA - 53

Part Op **100** - 1-Cut as per Dwg D2581 Dwg Rev: AI Prog Rev: AI 2-Deburr if necessary  
 Descriptions: **120** - (QC8- Inspect parts - second check)  
**130** - (small fab)Form as per dwg  
**140** - (QC5- Inspect part completeness to step on W/O)  
**150** - (Identify as per dwg & Stock Location: \_\_\_\_\_)  
**160** - (QC21- Final Inspection - Work Order Release)

**Job BOM**

| Part / Item | Component Name      | Quantity            | Operation               | Container |
|-------------|---------------------|---------------------|-------------------------|-----------|
| M304S11GA   | 304/316 0.125 Sheet | .7480 sf (.0187 ea) | 100-Waterjet - Flow - 1 | S159397   |

**Job Allocations**

| Operation               | Component Part | Required | Inventory | Allocated |
|-------------------------|----------------|----------|-----------|-----------|
| 100-Waterjet - Flow - 1 | M304S11GA      | 1        | 28        | 0         |

**Part Specifications**

| Spec No | Description      | Target/Tolerance               | Limits         | Type | Special Comments |
|---------|------------------|--------------------------------|----------------|------|------------------|
| 1       | Mounting Bracket | 0.328inches + 0.006<br>- 0.001 | 0.334<br>0.327 |      |                  |
| 2       | Mounting Bracket | 0.191inches + 0.005<br>- 0.001 | 0.196<br>0.190 |      |                  |
| 3       | Mounting Bracket | 0.750inches ± 0.010            | 0.760<br>0.740 |      |                  |
| 4       | Mounting Bracket | 3.596inches ± 0.010            | 3.606<br>3.586 |      |                  |
| 5       | Mounting Bracket | 2.846inches ± 0.010            | 2.856<br>2.836 |      |                  |
| 6       | Mounting Bracket | 1.995inches ± 0.010            | 2.005<br>1.985 |      |                  |
| 7       | Mounting Bracket | 0.250inches ± 0.010            | 0.260<br>0.240 |      |                  |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only



| Job: _____<br>Part No. _____                   |                                                       | DISPOSITION                                                                                                                          |                                             | DEPARTMENT/PROCESS                                                                                                                                  |  |
|------------------------------------------------|-------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Rework <input type="checkbox"/>                |                                                       | Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/>                       |                                             | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/>                                     |  |
| Scrap <input type="checkbox"/>                 |                                                       | Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/> |                                             | Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |
| Use-as-is <input type="checkbox"/>             |                                                       | Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/>                                                             |                                             | Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |
| Date: _____                                    | Sequence #: _____                                     | QTY Affected: _____                                                                                                                  |                                             | MRB (QS1042)                                                                                                                                        |  |
| Description Work Order Deviation               |                                                       | Disposition                                                                                                                          |                                             | Completed By                                                                                                                                        |  |
|                                                |                                                       |                                                                                                                                      |                                             | Lead hand / Supervisor                                                                                                                              |  |
|                                                |                                                       |                                                                                                                                      |                                             | QC / QA Coordinator                                                                                                                                 |  |
| Root Cause                                     |                                                       | FAULT CATEGORY                                                                                                                       |                                             |                                                                                                                                                     |  |
| Operator <input type="checkbox"/>              | Pressure/Forced <input type="checkbox"/>              | Contamination <input type="checkbox"/>                                                                                               | Power Loss/Surge <input type="checkbox"/>   | Positioned Wrong <input type="checkbox"/>                                                                                                           |  |
| Manufacturing Process <input type="checkbox"/> | Bending <input type="checkbox"/>                      | Misaligned/off center <input type="checkbox"/>                                                                                       | Folio/Program <input type="checkbox"/>      | Outside Tolerance <input type="checkbox"/>                                                                                                          |  |
| Equip/Tooling <input type="checkbox"/>         | Crushing <input type="checkbox"/>                     | BOM/Route <input type="checkbox"/>                                                                                                   | Grain Direction <input type="checkbox"/>    | Drawing <input type="checkbox"/>                                                                                                                    |  |
| Handling/Preservation <input type="checkbox"/> | Cracks <input type="checkbox"/>                       | Broken/Damage/Defect <input type="checkbox"/>                                                                                        | Weld <input type="checkbox"/>               | Finish <input type="checkbox"/>                                                                                                                     |  |
| Material <input type="checkbox"/>              | Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> | Incomplete/Unclear Instructions <input type="checkbox"/>                                                                             | Wrong Stock Pulled <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/>                                                                                                          |  |
| Product Improvement <input type="checkbox"/>   | Marks/Chatter <input type="checkbox"/>                | Drill Holes <input type="checkbox"/>                                                                                                 | Out of Sequence <input type="checkbox"/>    | Misread <input type="checkbox"/>                                                                                                                    |  |
| Process Improvement <input type="checkbox"/>   | Mislabeled <input type="checkbox"/>                   | Fit/Function <input type="checkbox"/>                                                                                                | Off-set/Set-up <input type="checkbox"/>     |                                                                                                                                                     |  |
| Human Factors <input type="checkbox"/>         | Other/Details: _____                                  |                                                                                                                                      |                                             |                                                                                                                                                     |  |